



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4103-1

Job Sheet 173804



Part No: D4103-1

Job Qty: 30 ea 40 mil

Part Name: Step / Handle



Part Weight: 0 lbs

Status: S

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 3/16/18

Type: Stock SOLD

Description:

Note: DWG REV A IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		3/13/18	0.00	0.00	Start Up Machining-2		Kt 2018-04-18
100	Bandsaw	30 pcs		3/14/18	0.00	24.39	Bandsaw1		Kt 2018-04-18
110	CNC Vertical Machining	30 pcs		3/15/18	0.12	38.46	HAAS1-4		Kt 2018-04-18
130	QC	30 pcs		3/15/18	0.00	0.00	QC8 Machining-2		26
140	HandFinish	30 pcs		3/16/18	0.00	2.07	HandFinish1		1804-26
150	QC	30 pcs		3/16/18	0.00	0.00	QC3		38
160	Packaging	30 pcs		3/16/18	0.00	0.00	Packaging3-2		APR 26 2018
170	QC21-SA	30 Ea		3/16/18	0.00	0.00	QC21		APR 26 2018

Part Op 100 - 6.200" long

Descriptions: 110 - Mill as per dwg and Folio FA937

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X03.500	6061-T6 Bar 2.00 X 3.50	15.6000 ft (.52 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X03.500	16	29	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step/Handle	2.930Inches $\pm$ 0.030	2.960 2.900		
2	Step/Handle	0.370Inches $\pm$ 0.030	0.400 0.340		
3	Step/Handle	0.830Inches $\pm$ 0.030			
4	Step/Handle	0.560Inches $\pm$ 0.010	0.590 0.550		
5	Step/Handle	0.060Inches $\pm$ 0.030	0.090 0.030		
6	Step/Handle	45.000Degrees			

M6061T6B2.000X03.500
S043708

M6061T6B2.000X03.500
S012849

DART
AEROSPACE

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Container No: S062237



Part: D4103-1

Job No: 173804

Serial No/Batch: S062237

Revision:

Inspector:

Date: 04/18/18

7	Step/Handle	0.260Inches ± 0.030	0.290 0.230	
8	Step/Handle	0.330Inches ± 0.030	0.360 0.300	
9	Step/Handle	0.060Inches ± 0.030	0.090 0.030	Radius
10	Step/Handle	1.780Inches ± 0.030	1.810 1.750	
11	Step/Handle	0.450Inches ± 0.030	0.480 0.420	
12	Step/Handle	0.330Inches ± 0.030	0.360 0.300	
13	Step/Handle	0.750Inches + 0.000 - 0.030	0.750 0.720	
14	Step/Handle	1.660Inches ± 0.030	1.690 1.630	
15	Step/Handle	0.800Inches ± 0.030	0.830 0.770	
16	Step/Handle	1.070Inches ± 0.030	1.100 1.040	
17	Step/Handle	3.850Inches ± 0.030	3.880 3.820	
18	Step/Handle	0.030Inches ± 0.030	0.060 0.000	
19	Step/Handle	45.000Degrees ± 0.500	45.500 44.500	Angle
20	Step/Handle	0.310Inches ± 0.030	0.340 0.280	
21	Step/Handle	0.280Inches ± 0.030	0.310 0.250	
22	Step/Handle	0.030Inches ± 0.030	0.060 0.000	Depth
23	Step/Handle	6.000Inches ± 0.030	6.030 5.970	
24	Step/Handle	0.270Inches ± 0.030	0.300 0.240	Radius
25	Step/Handle	0.560Inches ± 0.030	0.590 0.530	
26	Step/Handle	1.740Inches ± 0.030	1.770 1.710	
27	Step/Handle	2.500Inches ± 0.030	2.530 2.470	
28	Step/Handle	0.438Inches + 0.006 - 0.001	0.444 0.437	Diameter
29	Step/Handle	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter
30	Step/Handle	0.960Inches ± 0.030	0.990 0.930	
31	Step/Handle	0.260Inches ± 0.030	0.290 0.230	
32	Step/Handle	0.250Inches ± 0.030	0.280 0.220	
33	Step/Handle	2.250Inches ± 0.030	2.280 2.220	
34	Step/Handle	1.000Inches ± 0.030	1.030 0.970	
35	Step/Handle	0.200Inches ± 0.030	0.230 0.170	
36	Step/Handle	0.980Inches ± 0.030	1.010 0.950	
37	Step/Handle	0.320Inches ± 0.030	0.350 0.290	
38	Step/Handle	1.250Inches ± 0.030	1.280 1.220	
39	Step/Handle	0.190Inches ± 0.030	0.220 0.160	Radius

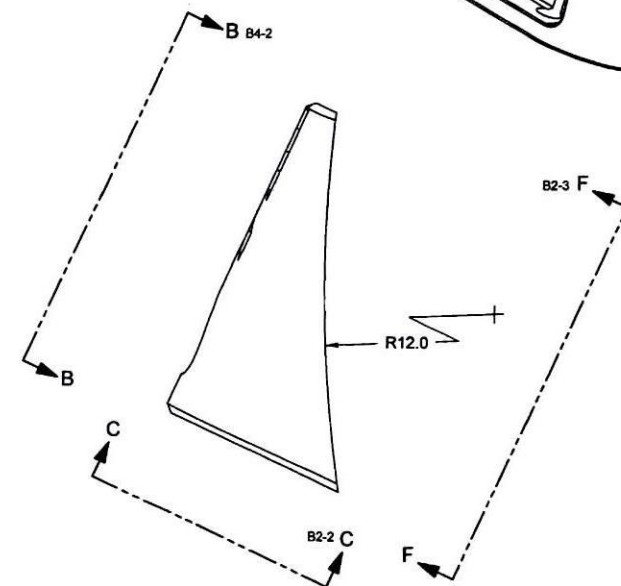
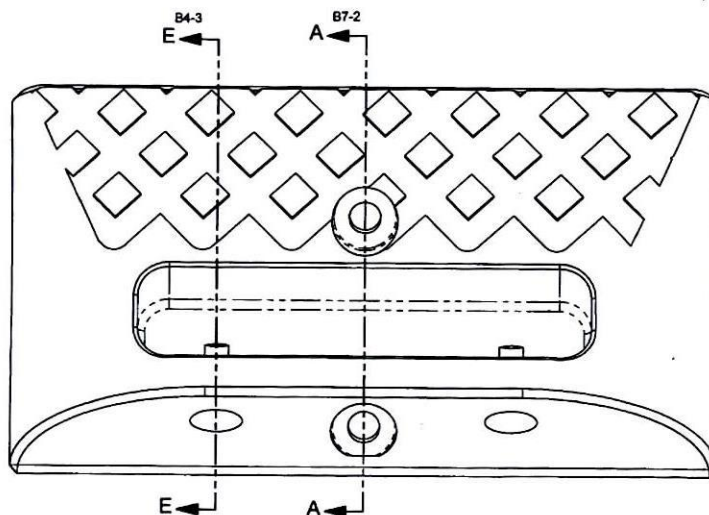
DART AEROSPACE LTD		Work Order:	171809
Description: Step/Handle		Part Number:	D4103-1
Inspection Dwg: D4103	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.932	✓		Vernier	
0.37	+/-0.030	.370	✓		Vernier	
0.83	+/-0.030	.829	✓		Vernier	
Ø0.560	+/-0.010	Ø.560	✓		Ring gage	
0.06 X 45°	+/-0.030 X +/-0.5°	.060 X 45°	✓		Vernier	
0.26	+/-0.030	.260	✓		Vernier	
0.33	+/-0.030	.326	✓		Vernier	
R0.06	+/-0.030	R.060	✓		Gaboril	
1.78	+/-0.030	1.786	✓		Vernier	
0.45	+/-0.030	.450	✓			
0.33	+/-0.030	.320	✓		Vernier	
0.75	+0.000/-0.030	.749	✓		Vernier	
1.66	+/-0.030	1.630	✓		Vernier	
0.80	+/-0.030	.795	✓		Vernier	
1.07	+/-0.030	1.079	✓			
3.85	+/-0.030	3.85	✓		Vernier	
0.03 X 45°	+/-0.030 X +/-0.5°	0.030 X 45°	✓		Vernier	
0.31	+/-0.030	.307	✓		Vernier	
0.28	+/-0.030	.280	✓		Vernier	
0.030 Deep	+/-0.030	.030	✓		Vernier	
6.00	+/-0.030	5.995	✓		Vernier	
R0.27	+/-0.030	R.27	✓		Gaboril	
0.56	+/-0.030	.552	✓		Vernier	
1.74	+/-0.030	1.745	✓		Vernier high gage	
2.50	+/-0.030	2.498	✓		Vernier	
Ø0.438	+0.006/-0.001	Ø.438	✓		Ring gage	
Ø0.266	+0.006/-0.001	Ø.266	✓		Ring gage	
0.96	+/-0.030	.935	✓		Vernier	
0.26	+/-0.030	.251	✓		Vernier	
0.25	+/-0.030	.240	✓		Vernier	
2.25	+/-0.030	2.250	✓		Vernier	
1.00	+/-0.030	.998	✓		Vernier	
0.20	+/-0.030	.198	✓		Vernier	
0.98	+/-0.030	.980	✓		Vernier	
0.32	+/-0.030	.350	✓		Vernier	
1.25	+/-0.030	1.244	✓		Vernier	
R0.19	+/-0.030	R.190	✓		Gaboril	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	2014/04/14	Date:	APR 25 2018	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>



D4103-1 STEP/HANDLE

RELEASED
2010-08-23
JWP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4103-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.81 lbs
- 8) MACHINE 0.28 x 0.31 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

A NEW ISSUE		RF	10.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	#		
MFG. APPR.	21		
APPROVED	#		
DE APPR.	#		
DATE	10.05.17		

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HAWKESBURY, ONTARIO, CANADA

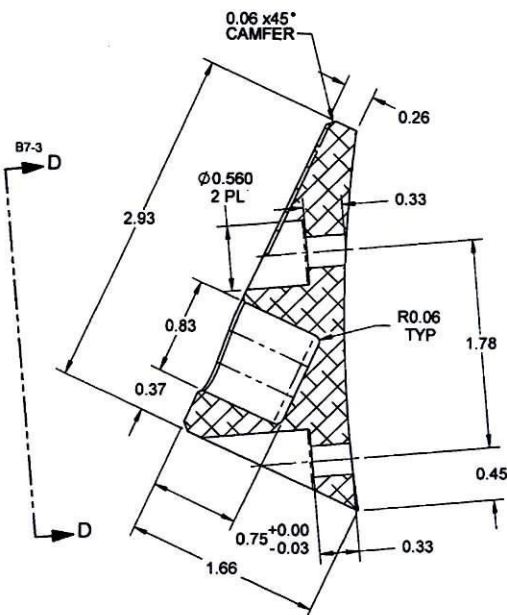
DRAWING NO.
D4103

REV. A
SHEET 1 OF 3

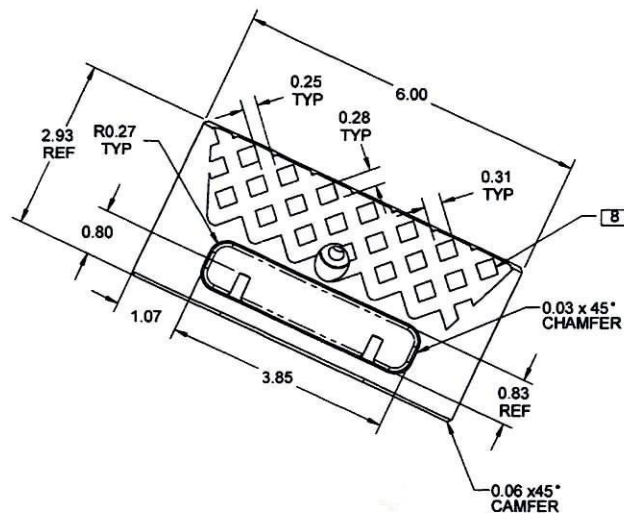
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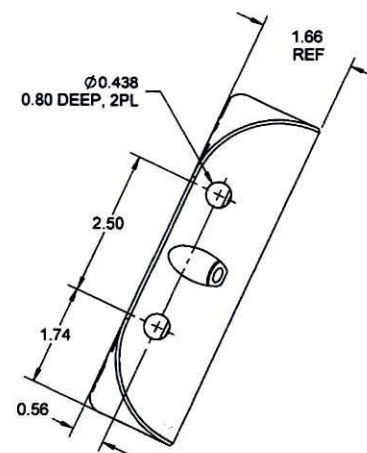
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SECTION A-A D6-1



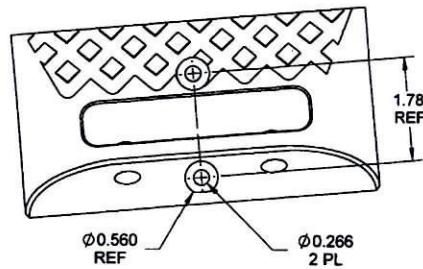
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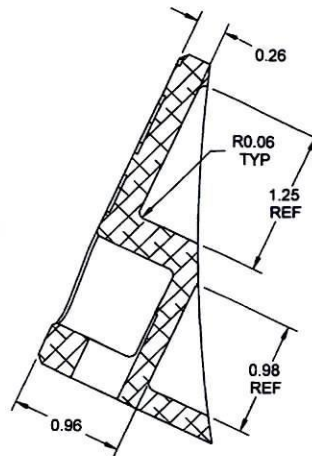
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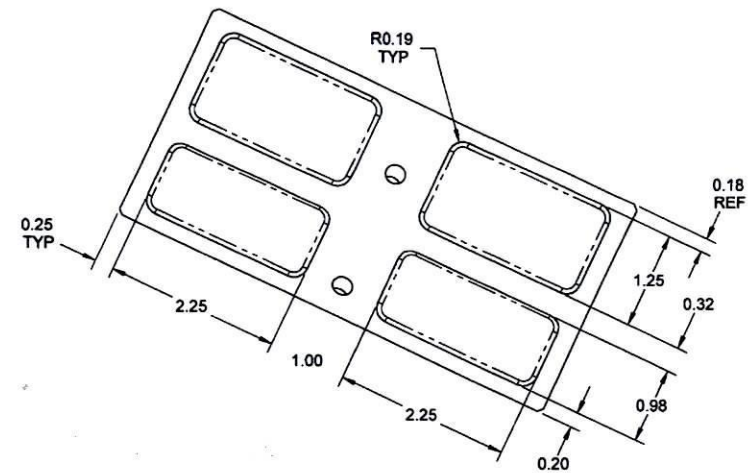
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VIEW D-D C8-2
SCALE 0.5X



VIEW E-E D7-1



VIEW F-F C1-1

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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